

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 5841 (1970): Fluted core cleaners for use in foundries
[MTD 14: Foundry]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

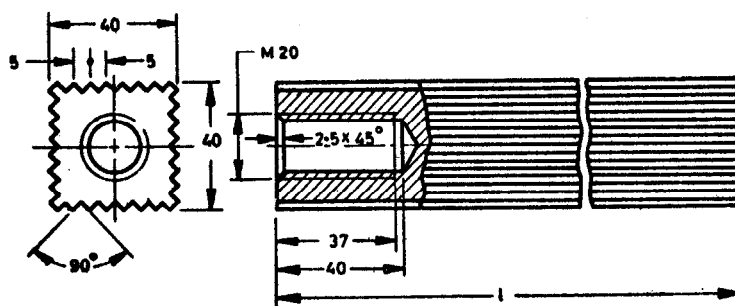
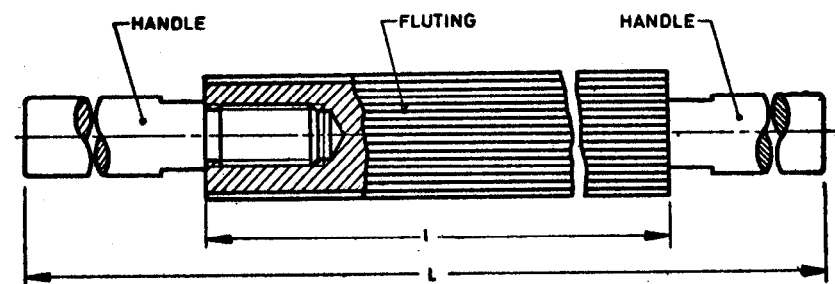
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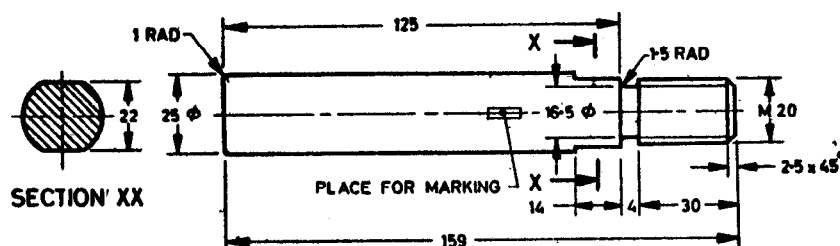


Indian Standard
**SPECIFICATION FOR
FLUTED CORE CLEANERS FOR USE IN FOUNDRIES**

1. **Scope** — The requirements for fluted core cleaners for use in foundries.
2. **Dimensions** — Dimensions of fluted core cleaners are specified in the following figure.



DETAIL OF FLUTING



DETAIL OF HANDLE

L	I
650	400
750	500
880	630

Designation — Fluted roller with overall length of 650 mm and fluting length of 400 mm shall be designated as :

Fluted Roller — 650 IS : 5841

3. Material

3.1 Fluting — Tool steel T80, IS : 3749-1966 ' Specification for tool and die steels for cold work '.

3.2 Handle — Structural steel St 32-0, IS : 1977-1962 'Specification for structural steel (ordinary quality) '.

4. Coating on Handle — Chromium plating according to IS : 1337-1968 'Specification for hard chromium electroplated coatings on iron and steel (first revision) '.

5. Hardness of Fluting — 50 to 55 HRC.

6. Tolerances

6.1 Threads

a) *Fluting* — Grade 6H Coarse, IS : 4218 (Part V) - 1967 'ISO metric screw threads: Part V Tolerances '.

b) *Handle* — Grade 6g Coarse, IS : 4218 (Part V) - 1967.

6.2 Tolerance on flatness of fluting along the length and flatness of roller along the width shall be ± 0.05 mm.

6.3 Other Tolerances — IT14, IS : 919-1963 'Recommendations for limits and fits for engineering (revised) '.

7. General — Surfaces of fluting shall be free from cracks, burrs, sharp edges, scales, etc, after heat treatment.

8. Marking — The core-cleaner shall be marked with the following:

- a) Trade-mark or name of the manufacturer, and
- b) Designation.

8.1 ISI Certification Marking — Details available from the Indian Standards Institution.

9. Packing — The unprotected surfaces shall be coated with a thin film of protective oil. The fluting shall be wrapped in moisture proof paper. The tools shall be packed in wooden boxes weighing not more than 50 kg overall.

10. Supply — According to IS : 1387-1967 'General requirements for the supply of metallurgical materials (first revision) '.